



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4406-3

Job Sheet 176927



Part No: D4406-3

Job Qty: 1 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/11/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D IPP REV:A 14.04.09 DWG REV:C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/11/18	0.00	0.00	Start Up Waterjet		SC 18/05/04
100	Waterjet	4 pcs		5/11/18	0.00	0.80	Waterjet1		SC 18/05/04
110	QC	4 pcs		5/11/18	0.00	0.00	QC2 Waterjet-3		SC 18/05/04
120	QC	4 pcs		5/11/18	0.00	0.00	QC8-4		38
130	Small Fab	4 pcs		5/11/18	0.21	0.72	Small Fab-6		38
140	QC	4 pcs		5/11/18	0.00	0.00	QC5		38
150	Packaging	4 pcs		5/11/18	0.00	0.00	Packaging3		9-39
160	QC21-SA	4 Ea		5/11/18	0.00	0.00	QC21		21

MAY 29 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	11.6800 sf (2.92 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	12	129	0

Part Specifications

Specifications could not be found.

Plex 5/3/18 9:53 AM dart.lacelle.linda



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S068679



Part: D4406-3

Job No: 176927

Serial No/Batch: S068679

Revision:

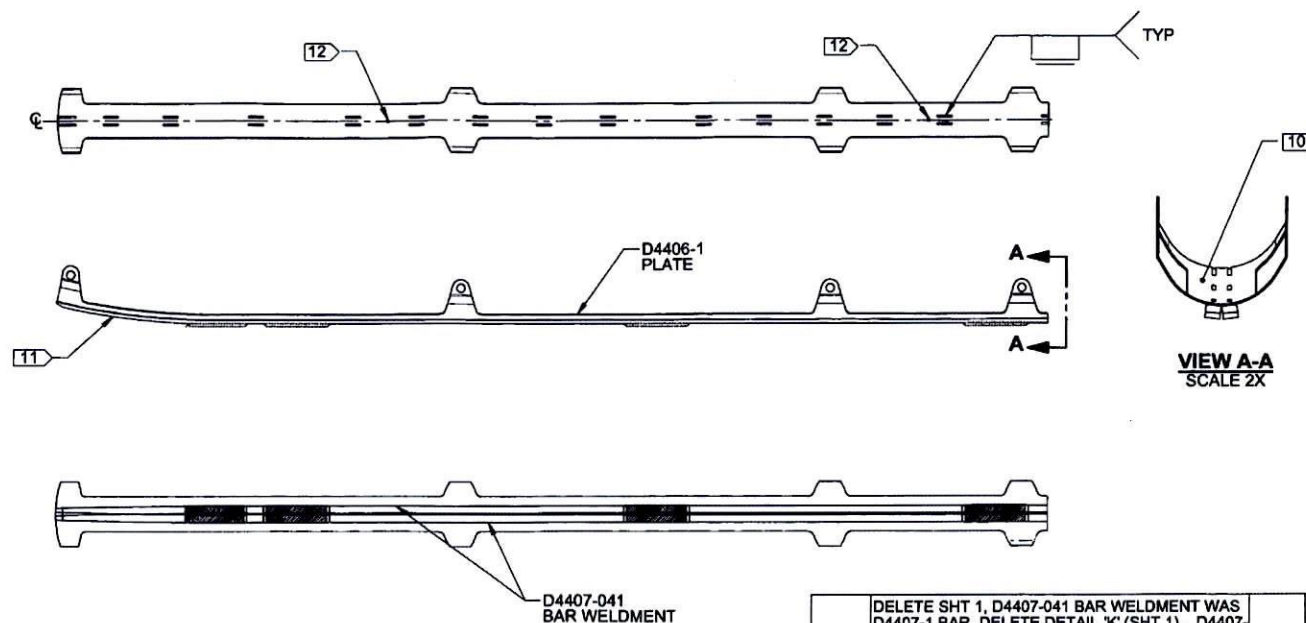
Inspector:

Date: 05/04/18

038
32
NY2

K

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4406-041	FWD WEARPLATE ASSY
1	1	D4406-1	PLATE
2	2	D4407-041	BAR WELDMENT



D4406-041 FWD WEARPLATE ASSY

NOTES:

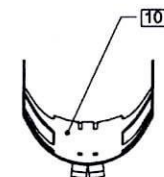
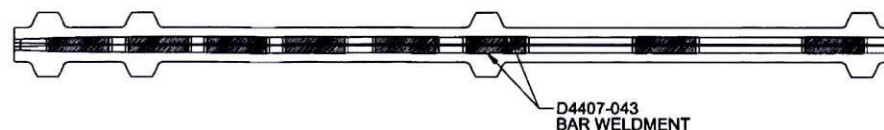
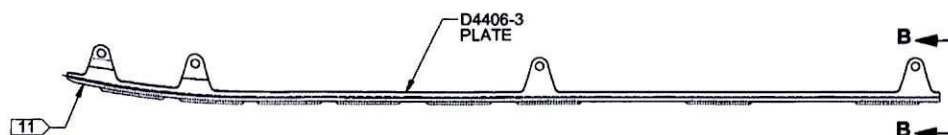
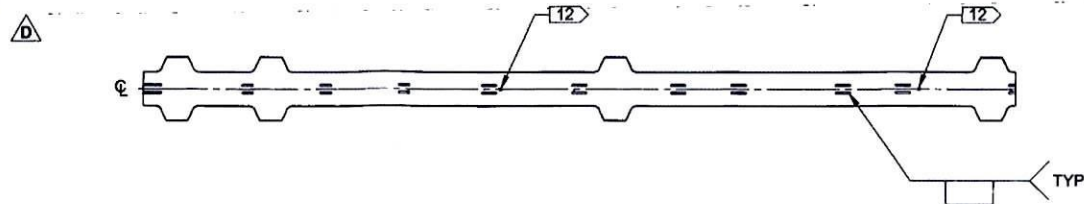
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.48 lbs
- 8) WELDING: PER QSI 004
- 9) N/A
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING.
- 12) TRANSFER $\phi 0.188$ HOLES FROM D4406-1 TO D4407-041

D	DELETE SHT 1, D4407-041 BAR WELDMENT WAS D4407-1 BAR, DELETE DETAIL 'K' (SHT 1), D4407-043 BAR WELDMENT WAS D4407-3 BAR, DELETE DETAIL 'L' (SHT 2), REMOVE NOTE 9 (SHT 1&2), NOTE 10; TEXTURED COATING WAS ROCKGUARD (SH 1&2), NOTE 12; D4407-041 WAS D4407-1 (SHT 1), D4407-043 WAS D4407-3 (SHT 2), REMOVE NOTE 13 (SHT 1&2)	DB	15.10.14
C	SHEETS 4 AND 5 HOLE SLOTS RE-PITCHED, SHT 5 FWD SLOT SIZES WERE 0.88 (REF NCR12-2031)	AJS	13.03.11
B	REVISE BILL OF MATERIAL: ADD NOTE 13/14 & REVISE NOTE 9 SHT 2&3; MODIFY DETAIL E & F (ZN B3-6, C2-6); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	ML	DRAWING NO. D4406	
MFG. APPR.	DD		
APPROVED	WM	TITLE WEARPLATE ASSY	
DE APPR.	DS		
DATE	15.10.14	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2016-02-08
REN 16-518

APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4406-043	WEARPLATE ASSY
1	1	D4406-3	PLATE
2	2	D4407-043	BAR WELDMENT



VIEW B-B
SCALE 2X

D4406-043 AFT WEARPLATE ASSY

NOTES:

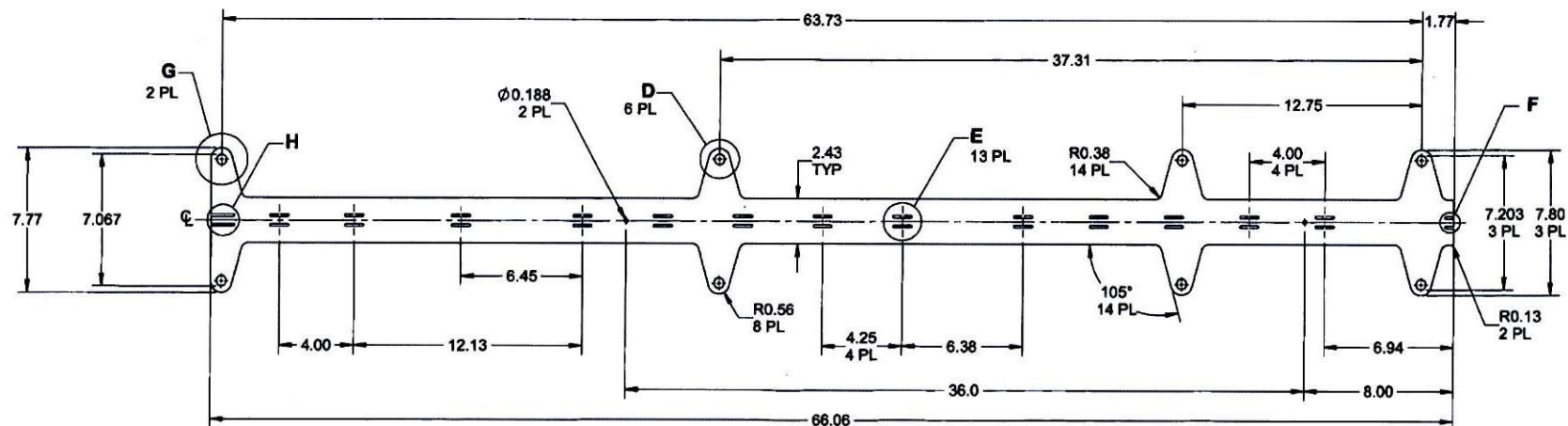
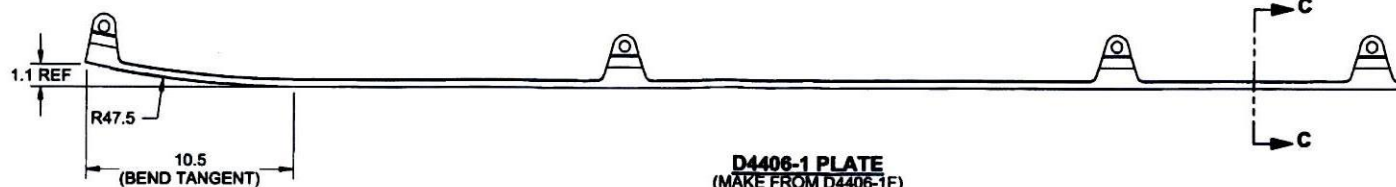
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.70 lbs
- 8) WELDING: PER QSI 004
- 9) N/A
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING.
- 12) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-3 TO D4407-043

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2016-02-08

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DRAWN	DB
CHECKED	ML
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	15.10.14

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. D
D4406	SHEET 2 OF 5
TITLE	SCALE
WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

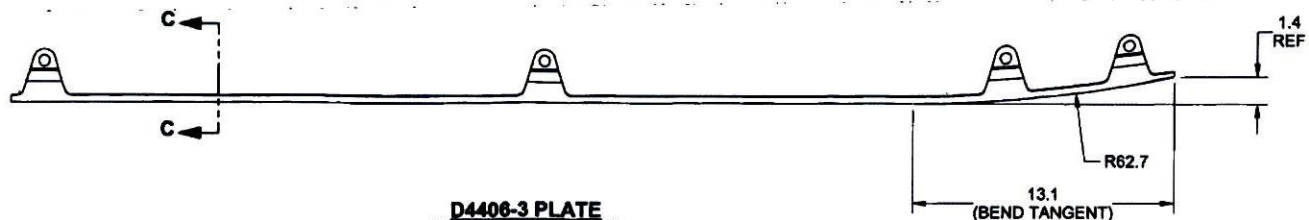
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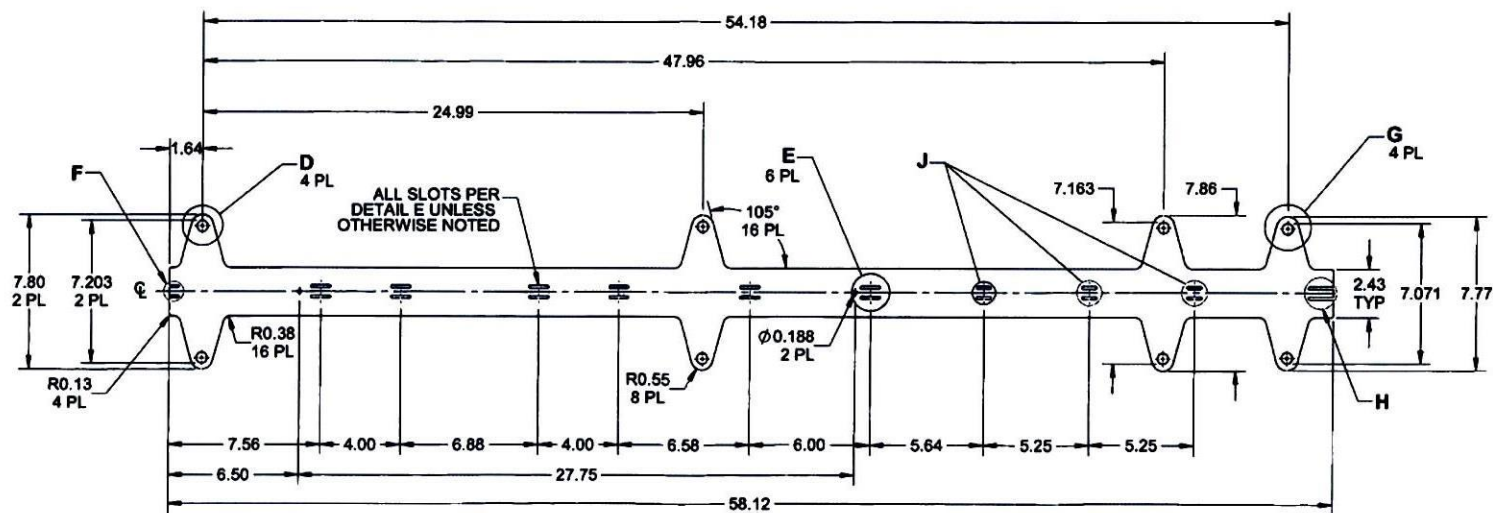
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DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D4406	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4406-3 PLATE
(MAKE FROM D4406-3F)



D4406-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.5 lbs

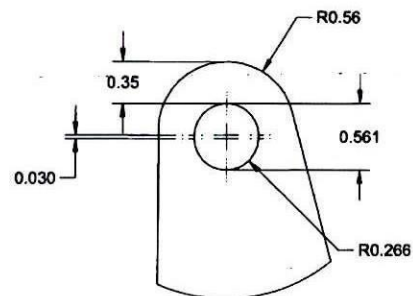
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2016-02-08

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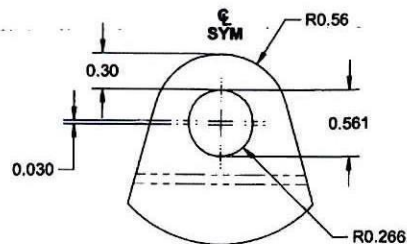
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CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D4406	SHEET 4 OF 5
APPROVED	WM	TITLE	SCALE
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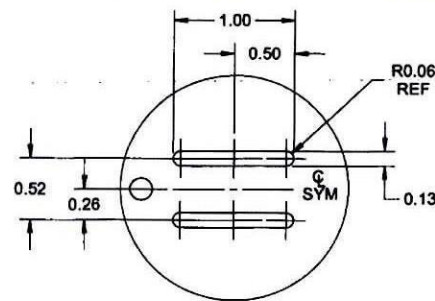
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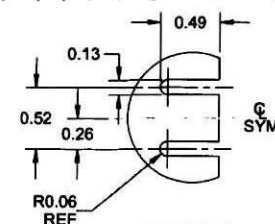
DETAIL G
SCALE 6X



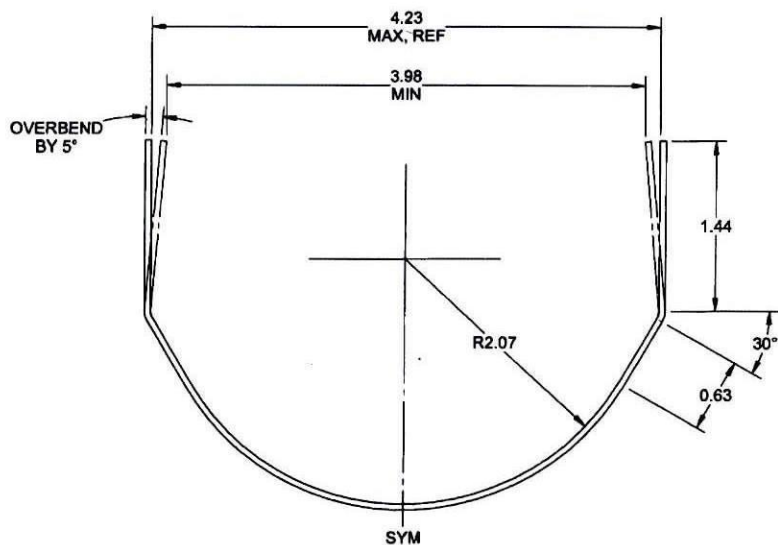
DETAIL D
SCALE 6X



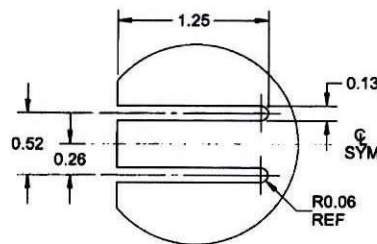
DETAIL E
SCALE 6X



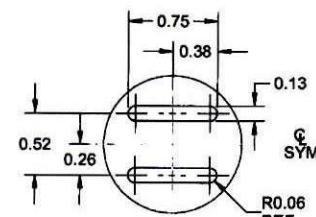
DETAIL F
SCALE 6X



DETAIL C
DETAIL TYP
SCALE 6X



DETAIL H
SCALE 6X



DETAIL J
SCALE 6X

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2016-02-08

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DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D4406	SHEET 5 OF 5
APPROVED	WM	TITLE	SCALE
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8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	176927
Description: Plate		Part Number:	D4406-3
Inspection Dwg: D4406	Rev: D	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
54.18	+/- 0,030	54.18	1		USC-01	
47.96	+/- 0,030	47.96	1		Tape	
24.99	+/- 0,030	24.99	1			
58.12	+/- 0,030	58.12	1			
27.75	+/- 0,030	27.75	1			
7.80	+/- 0,030	7.80	1			
7.203	+/- 0,010	7.206	1			
1.64	+/- 0,030	1.64	1			
7.56	+/- 0,030	7.562	1			
6.50	+/- 0,030	6.501	1			
4.00	+/- 0,030	4.003	1			
6.88	+/- 0,030	6.886	1			
4.00	+/- 0,030	4.003	1			
6.58	+/- 0,030	6.585	1			
6.00	+/- 0,030	6.00	1			
5.64	+/- 0,030	5.646	1			
5.25	+/- 0,030	5.252	1			
5.25	+/- 0,030	5.251	1			
7.163	+/- 0,010	7.165	1			
7.86	+/- 0,030	7.862	1			
2.43	+/- 0,030	2.431	1			
7.071	+/- 0,010	7.072	1			
7.77	+/- 0,030	7.78	1			
9.501	+/- 0,010	9.562	1			
0.35	+/- 0,030	0.355	1			
1.00	+/- 0,030	1.003	1			
0.13	+/- 0,030	0.131	1			
0.75	+/- 0,030	0.75	1			
0.050	+/- 0,010	0.048			DAS	

Measured by: SC	Checked by: 38	QC Inspector:
Date: 19/05/04	Date: MAY 08 2018	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	